

Date: Monday, 22/10/2007 2:17:19 PM
User: Linda Lacelle

Process Sheet

H. Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 35297 ~~23~~
 Estimate Number : 12883
 P.O. Number :
 This Issue : 22/10/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 35031
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07.05.24 EC
 Est Rev B ECN 987 07.10.09 EC

Drawing Name : ARM
 Part Number : D3560043
 Drawing Number : D3560 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 29/10/2007 Qty: 14 Um: Each
*J/J 2
15*

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
Comment: Qty.: 1.3598 f(s)/Unit Total : 19.0365 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: PT06182		<i>OK 07/11/30</i> (14)
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 15.500" long		<i>OK 07/11/30</i> (14)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		<i>OK 07/12/07</i>
1- Mill as per Folio FA695 Rev: <u>A</u> & Dwg D3560 Rev: <u>C</u>		
2-C'sink 0.196" hole on manual mill as per dwg D3560		
3-Deburr per dwg D3560		<i>OK 07/12/07</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>OK 07/12/02</i>
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		<i>OK 07/12/11</i> (14)

John W. Johnson
L. & L. Johnson
Johnson & Johnson

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Drawing Name: ARM

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Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D35921 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
PLATE

SP
B42279

08.09.30

(3x)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad) SP SP

2- set up bracket and arm on jig SP SP

3- preheat bracket and arm with torch SP SP

4- clean before welding with brush SP SP

5- set up machine to 135 amps SP SP

6- weld across bottom and top ends SP SP

7- reheat with torch () SP SP

8- on one side weld from bottom to top half way SP SP

9- same for other side (half way) SP SP

10- from half way point weld the rest of the first side (ease off pedal near end) SP SP 08.09.30 (3x)

11- same for remaining side (ease off pedal near end) SP SP 08-07-10 SP (4x)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-30 (1)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RL

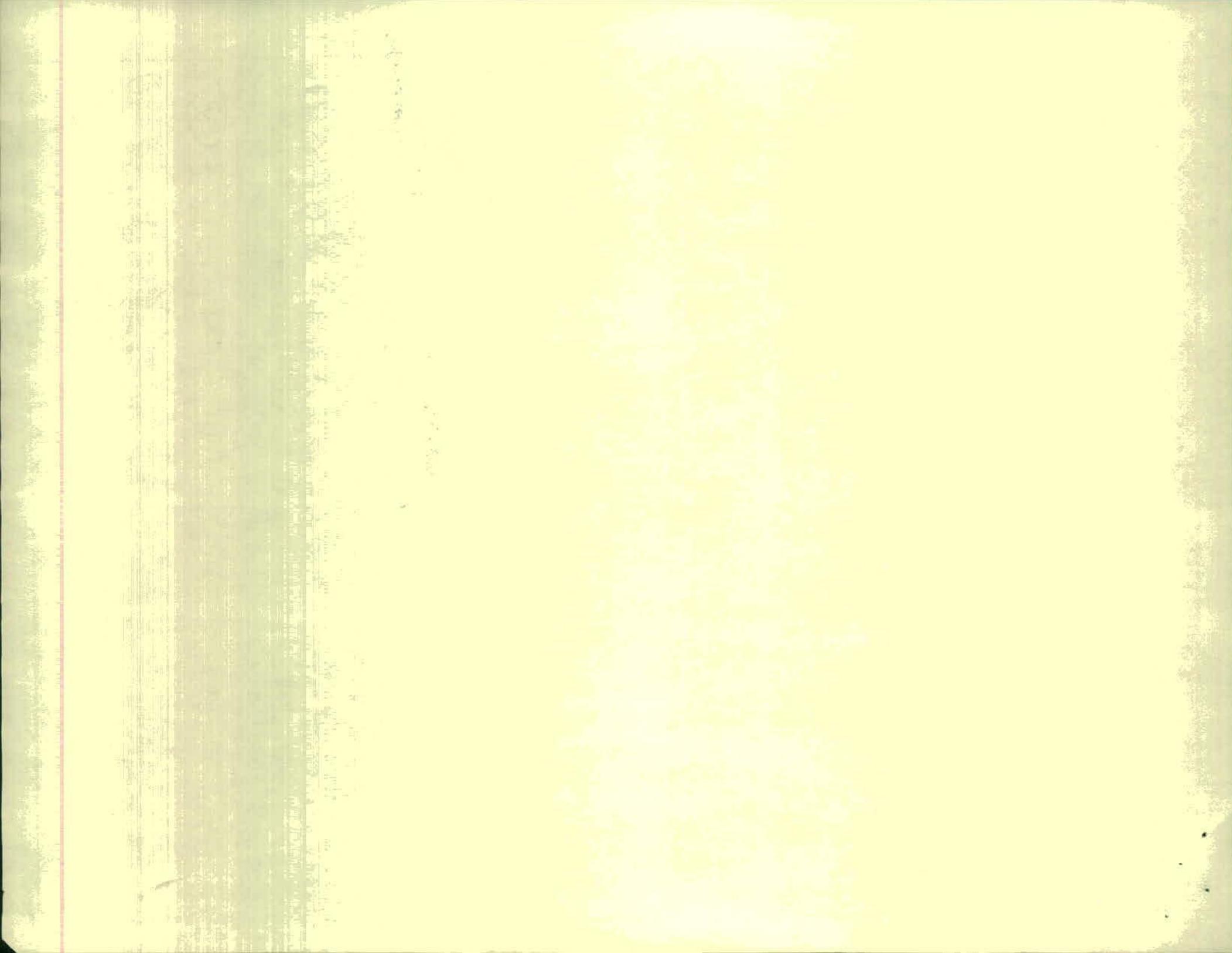
08-10-02 (xx)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RL 08/10/02 (1)



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Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D2808 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Spacer

batch: B37113

EP 08/10/02 Q

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

EP 08/10/02 Q

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/02 Q

15.0 PACKAGING 1 PACKAGING RESOURCE #1



(Q)

Comment: PACKAGING RESOURCE #1

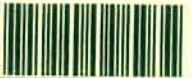
Identify and Stock

Location: B2

8160 12

5Q

16.0 QC21 FINAL INSPECTION/W/O RELEASE



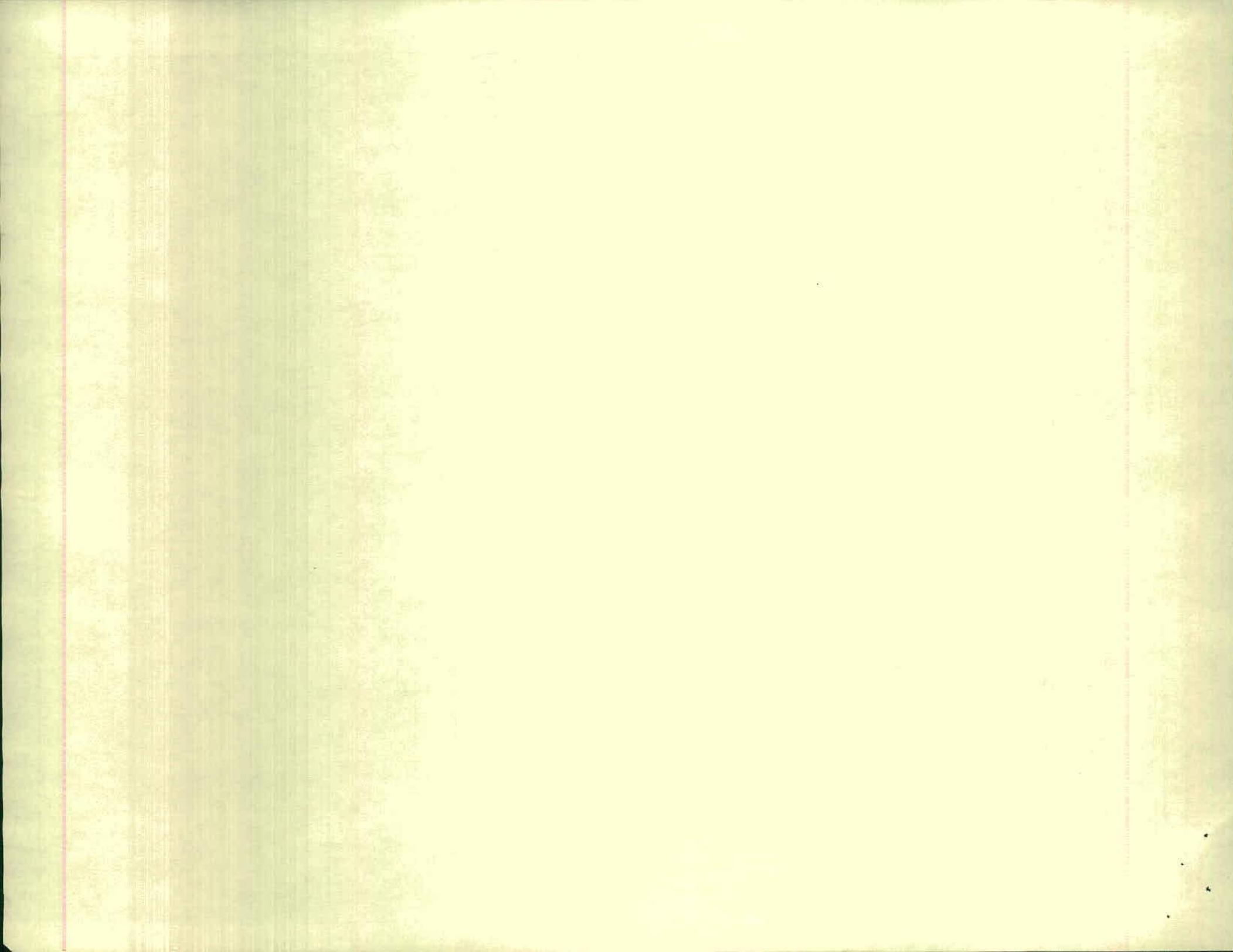
08/10/03 HJ

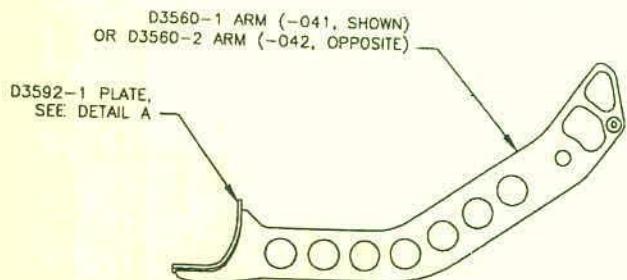
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

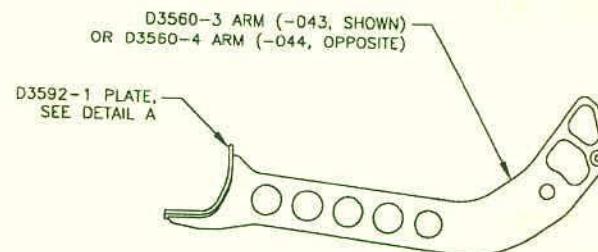


U 08.10.03

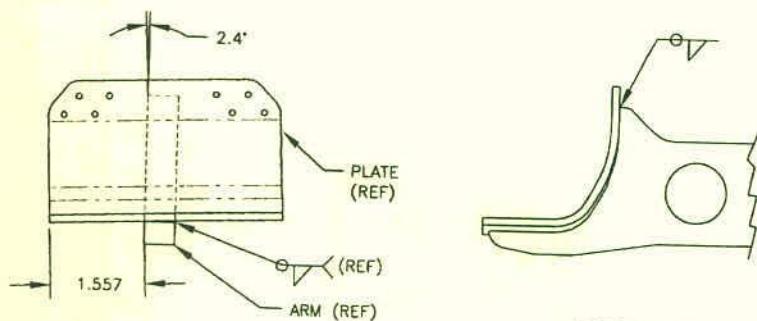




D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.22 DC

UNDER REVIEW

07.10.22 DC

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DART AEROSPACE LTD.

DESIGN	07.06.19	DRAWN BY	07.06.19	REMOVE POWDER COAT
CHECKED	#	APPROVED	#	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25			NEW ISSUE
				DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA
				REV. C SHEET 1 OF 3
DATE	07.06.19	TITLE	ARM WELDMENT	SCALE

DART AEROSPACE LTD	Work Order:	35247
Description: Arm	Part Number:	D3560-3
Inspection Dwg: D3560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: SP
Date: 07/12/07

Audited by:	J.L.
Date:	07/12/07

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	

0.188 (TYP) 0.188 (TYP ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED)

6.21

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°.
SEE SECTION C-C

0.250 C BORE $\phi 0.507^{+0.001}_{-0.001}$
0.250 DEEP FROM
THIS SIDE

R0.35 (TYP) R0.40

R0.375

R0.49

R0.75

2.913

4.264

13.952

14.33

12.433

13.10

8.654

9.58

7.279

5.904

4.529

3.154

2.93

2.76

1.750

1.702

0.000

2.107

0.000

2.090

C

C

0.275 (TYP)

0.250

0.250 DEEP FROM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-043 PAR #: N/A Fault Category: Eng/Dur NCR: Yes No DQA: Date: 08/10/01
 Resolution: Scrap Disposition: SC RND QA: N/C Closed: Date: _____

NCR: 35297		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
08/10/01	7.0	2 parts were found with cracks. R.C: Design & tricky process.	J QSIU12	Scrap: destroy. SEE CAR 08-026	SAD 08/10/01	/08.10.01	/QSIU12	/08.10.01

NOTE: Date & initial all entries

12 CSK

1510